

# Work Order ID 48560

June 26, 2009 7:31:57 AM



Page 1

Item ID: D3629-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Bracket

Start Date: 15/07/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3629

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3629  
Deburr if necessary

Dwg Rev: A

Prog Rev: A

1-2-

B 9-6-30

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B 9-6-30

36

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

509/07/01

36

counts

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Cust Item ID:

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Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Bend as per dwg D3629112-Tumble

SD 02/07/02  
B 9/7/12

34  
36

140

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

=> SD 02/07/02

counters  
(436)

150

0.00



Packaging

Identify as per dwg & Stock Location

Memo

0.00

Packaging

244A

9/7/06

(300) SD

# Work Order ID 48560

June 26, 2009 7:31:57 AM



Page 3

Item ID: D3629-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Bracket

Start Date: 15/07/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/07

4 09-07-06

# Picklist Print

June 26, 2009 7:31:56 AM

Page 1

Work Order ID: 48560



Parent Item: D3629-1RevA



Parent Item Name: Bracket



Start Date: 15/07/2009

Required Date: 03/08/2009

Comments:

Start Qty: 20.00

Required Qty: 20.00

| Component Item ID/<br>Item Name   | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick  | Qty<br>Issued | Date<br>Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|---|---------------|----------------|--------|
| M304S16GA   |                        | Purchased     | No          |                     |                  | 100             | sf                 | 0.0000         | 1.5789  |               |                |        |
|  |                        | m 111924      |             | IB 9-6-30           |                  |                 |                    |                |  |               |                |        |

304/316 Sheet.063

Date: Friday, 12/06/2009 9:58:17 AM  
 User: Julie Dawson

## Process Sheet

|                                    |                                     |                           |             |
|------------------------------------|-------------------------------------|---------------------------|-------------|
| <b>Customer</b> :                  | CU-DAR001 Dart Helicopters Services | <b>Drawing Name</b> :     | BRACKET     |
| <b>Job Number</b> :                | 48560                               |                           |             |
| <b>Estimate Number</b> :           | 12977                               |                           |             |
| <b>P.O. Number</b> :               |                                     | <b>Part Number</b> :      | D36291      |
| <b>This Issue</b> :                | 12/06/2009                          | <b>S.O. No.</b> :         |             |
| <b>Prsht Rev.</b> :                | NC                                  | <b>Drawing Number</b> :   | D3629 REV.A |
| <b>First Issue</b> :               | / /                                 | <b>Project Number</b> :   | N/A         |
| <b>Previous Run</b> :              | 43316                               | <b>Drawing Revision</b> : | A           |
|                                    | <b>Type</b> :                       | <b>Material</b> :         |             |
|                                    | SMALL /MED FAB                      | <b>Due Date</b> :         | 19/06/2009  |
| <b>Written By</b> :                |                                     | <b>Qty:</b>               | 20          |
| <b>Checked &amp; Approved By</b> : | <u>Julie Dawson</u>                 | <b>Um:</b>                | Each        |
| <b>Comment</b> :                   | Est Rev:A New Issue 07-07-24 ec     | <b>Verified By:</b>       | JLM         |

## Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

|     |           |                    |
|-----|-----------|--------------------|
| 1.0 | M304S16GA | 304/316 Sheet .063 |
|-----|-----------|--------------------|



**Comment:** Qty.: 0.0788 sf(s)/Unit Total : 1.5750 sf(s)

M304 stainless steel sheet 0.063" thick

Batch: M111924 1B 9-6-30

|     |           |                |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



**Comment:** FLOW WATER JET

1-Cut as per Dwg D3629

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

1B 9-6-30

1B 9-6-30

|     |     |  |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



1B 9-6-30



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

|     |     |              |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



**Comment:** SECOND CHECK

|     |             |                               |
|-----|-------------|-------------------------------|
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Bend as per dwg D3629

2-Tumble

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Friday, 12/06/2009 9:58:17 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 48560

Part Number: D36291

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock  
Location: \_\_\_\_\_

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

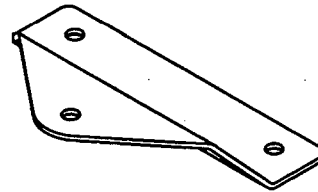
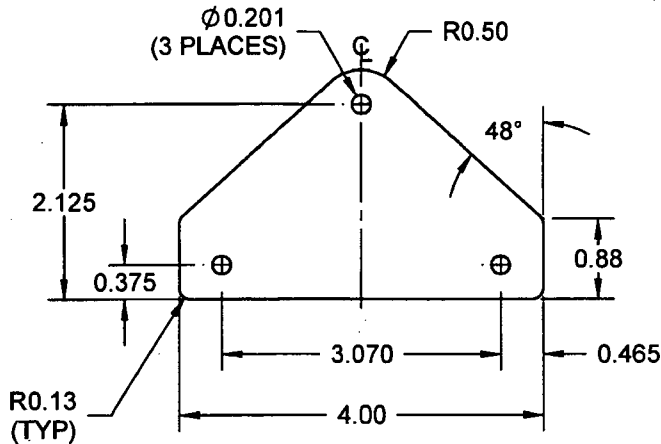
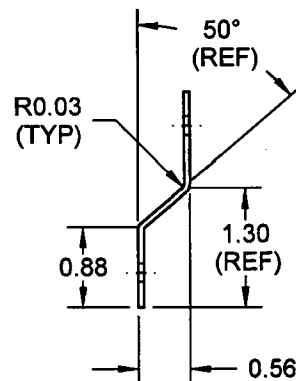
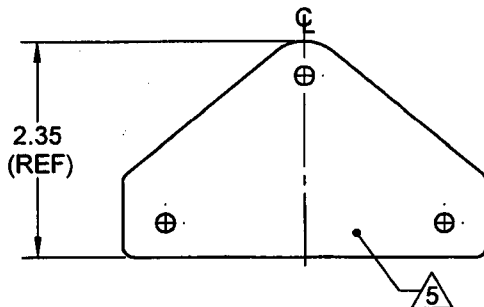
**NOTE:** Date & initial all entries





**DART**

|                         |                      |  |                        |
|-------------------------|----------------------|--|------------------------|
| DESIGN<br><i>B</i>      | DRAWN BY<br><i>B</i> | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>PH</i>    | APPROVED<br><i>H</i> | DRAWING NO.<br><b>D3629</b>                              | REV. A<br>SHEET 1 OF 1 |
| DATE<br><b>07.05.10</b> |                      | TITLE<br><b>BRACKET</b>                                  | SCALE<br>1:2           |
| REV<br>A                | DATE<br>07.05.10     | DESCRIPTION<br>NEW ISSUE                                 |                        |

**RELEASED**07.07.11 *H***⚠ D3629-1F BRACKET FLAT PATTERN****D3629-1 BRACKET**  
(MAKE FROM D3629-1F)**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.063 THICK, REF)  
PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) PART IS SYMMETRIC ABOUT  $\text{C}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) IDENTIFY WITH DART P/N "D3629-1" USING FINE POINT PERMANENT INK MARKER
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

SHOP COPY

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ENGINEERING

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SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER

NO. *48560*

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